

Work Order ID 84912

84912

Page 1

Item ID: D209-669-014

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/30

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D209-669-014 | Rev B | | | | | | | | |
| DSI 9450 | Rev A | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | DOCUMENT CONTROL | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Document Control | Photocopy bluefile & type labels per PPP D209-669-014 CHG003 | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

DAS 16
9-83
12/04/23
per EUN 12-599

12-7-12 SP

B84893

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 84912

84912

Page 2

May-29-12 1:07:24 PM

Item ID: D209-669-014

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 29/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS 16 12/07/23

130

Packaging

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD209-669-014

Location: _____

SNIP

12/07/23

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/07/23

MLJ 12/07/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 84912

84912

Parent Item: D209-669-014

D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: New IPP 08.02.13 new issue EC, verified by:DD
IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D209-669-043

Manufactured No

110

Each

2.0000

1

1

**

84893

D209-669-043

Replacement Skidtube

Location

Loc Qty

Loc Code

Mezz

2

39205

1

39206

1

D2917-2

Manufactured No

110

Each

1.0000

2

2

**

384939

D2917-2

Saddle RH

Location

Loc Qty

Loc Code

ST424

1

52129

1

D2918-2

Manufactured No

110

Each

1.0000

2

2

**

384940

12-7-12 SP

D2918-2

Saddle RH

Location

Loc Qty

Loc Code

ST424

1

52133

1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 84912

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

84912

D209-669-014

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-51A

Purchased

No

110

Each

302.0000

8

8

**

AN4-51A

Bolt

Location

Loc Qty

Loc Code

362

200

121181

200

ST361

102

119798

30

121584

72

D2570

Manufactured

No

110

Each

711.0000

24

24

**

D2570

Bushing

Location

Loc Qty

Loc Code

ST011

711

72960

41

78586

9

79493

12

81956

24

81957

400

82874

225

MS21042L4

Purchased

No

110

Each

4,095.000

24

24

**

MS21042L 4

Nut

Location

Loc Qty

Loc Code

ST300

4095

119075

125

121011

713

121444

2957

121652

300

May-29-12 1:07:28 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 84912

84912

Parent Item: D209-669-014

D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-36A

Purchased

No

110

Each

184.0000

4

4

AN5-36A

Bolt

**

Location

Loc Qty

Loc Code

340

134

121181

34

121652

100

ST340

50

121708

50

AN960JD516

NAS1149D0563J

Purchased

No

110

Each

0.0000

8

8

AN960JD516

Washer

**

MS21042L5

Purchased

No

110

Each

1,447.000

4

4

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

947

108827

8

116105

5

116548

43

117611

18

119109

865

17651

8

AN4-7A

Purchased

No

110

Each

124.0000

16

16

AN4-7A

Bolt

**

Location

Loc Qty

Loc Code

ST356

124

117514

24

120770

100

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Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 84912

84912

Parent Item: D209-669-014

D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased No

110 Each 30.0000 32 32

AN960.ID416

Washer

**

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

D2929 Manufactured No

110 Each 86.0000 2 2

D2929

Spacer

**

Location

Loc Qty

Loc Code

ST021

86

53564

86

D2930 Manufactured No

110 Each 102.0000 2 2

D2930

Spacer

**

Location

Loc Qty

Loc Code

ST021

102

53563

102

D3405-041 Manufactured No

110 Each 6.0000 1 1

D3405-041

Lug Assembly

**

Location

Loc Qty

Loc Code

ST478

6

62227

2

77000

2

82031

1

82032

1

May-29-12 1:07:28 PM

Shop Packet Print

Page 4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 5

Work Order ID: 84912

84912

Parent Item: D209-669-014

D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C47A

Purchased

No

110

Each

48.0000

4

4

AN4C47A

Bolt

**

MAY 2012

Location

Loc Qty

Loc Code

ST361

48

118451

6

119798

2

121009

22

121585

18

MS21043-4

Purchased

No

110

Each

1,346.000

5

5

MS21043-4

Nut

**

5

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1306

119546

147

121162

659

121652

500

D3405-043

Manufactured

No

110

Each

2.0000

1

1

D3405-043

Lug Assembly

**

B86941 12/7/12

Location

Loc Qty

Loc Code

ST478

2

82038

2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 84912

84912

Parent Item: D209-669-014

D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

110

Each

27.0000

1

1

D3407-041

Tow Ring

**

86672

Location

Loc Qty

Loc Code

ST463

27

82067

6

82068

19

82108

2

D3456-1

Manufactured No

110

Each

156.0000

1

1

D3456-1

Washer

**

54

127112

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

149

80252

1

81876

48

83584

100

D3417-5

Manufactured No

110

Each

78.0000

2

2

D3417-5

Washer

**

127112

Location

Loc Qty

Loc Code

ST042

78

78842

28

83318

50

May-29-12 1:07:28 PM

Shop Packet Print

Page 6

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84912-1125
12/05/30

| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | AJS | 09.02.24 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9450 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE INSTALLATIONS | NTS |
| DATE | 09.02.24 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR OTHERWISE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |
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NOTE: Date & initial all entries

5.0 PARTS LIST

| ITEM | QTY -011 | QTY -012 | QTY -013 | QTY -014 | QTY -041 | QTY -043 | PART NUMBER | DESCRIPTION |
|------|-------------|-------------|-------------|-------------|-------------|-------------|--------------|--|
| | X | | | | | | D209-669-011 | SKIDTUBE INSTALLATION, LH (AH-1W/J) |
| | | X | | | | | D209-669-012 | SKIDTUBE INSTALLATION, RH (AH-1W/J) |
| | | | X | | | | D209-669-013 | SKIDTUBE INSTALLATION, LH (AH-1P/F/S) |
| | | | | X | | | D209-669-014 | SKIDTUBE INSTALLATION, RH (AH-1P/F/S) |
| | 1 | 1 | | | X | | D209-669-041 | REPLACEMENT SKIDTUBE (AH-1W/J) |
| | | | 1 | 1 | | X | D209-669-043 | REPLACEMENT SKIDTUBE (AH-1P/F/S) |

IS:

| | | | | | | | | |
|----|----|----|---|---|--|--|-----------|-------------------|
| 50 | 4 | 4 | 1 | 1 | | | D3405-041 | LUG ASSEMBLY |
| 51 | 8 | 8 | 4 | 4 | | | AN4C47A | BOLT |
| 52 | 16 | 16 | 8 | 8 | | | D2570 | BUSHING |
| 53 | 8 | 8 | 4 | 4 | | | MS21043-4 | NUT |
| 54 | | | 1 | 1 | | | D3405-043 | LUG ASSEMBLY |
| 60 | 1 | 1 | 1 | 1 | | | D3407-041 | TOW RING ASSEMBLY |
| 61 | 1 | 1 | 1 | 1 | | | D3456-1 | WASHER |
| 62 | 1 | 1 | 1 | 1 | | | MS21043-4 | NUT |
| 63 | 2 | 2 | 2 | 2 | | | D3417-5 | WASHER |

WAS:

| | | | | | | | | |
|----|----|----|---|---|--|--|-----------|--------------------|
| 50 | 4 | 4 | 1 | 1 | | | D2736-1 | GHW LUG |
| 51 | 8 | 8 | 4 | 4 | | | AN4-46A | BOLT |
| 52 | 16 | 16 | 8 | 8 | | | D2570 | BUSHING |
| 53 | 8 | 8 | 4 | 4 | | | MS21042L4 | NUT (OR MS21042-4) |
| 54 | | | 1 | 1 | | | D2736-3 | GHW LUG |
| 60 | 1 | 1 | 1 | 1 | | | D2968-041 | TOW RING |
| 61 | 1 | 1 | 1 | 1 | | | AN970-4 | WASHER |
| 62 | 1 | 1 | 1 | 1 | | | MS21042L4 | NUT (OR MS21042-4) |

| | | | |
|------------|----------|---|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9450 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE INSTALLATIONS | NTS |
| DATE | 09.02.24 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS PERMISSION OF DART AEROSPACE LTD.</small> | |

24912

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

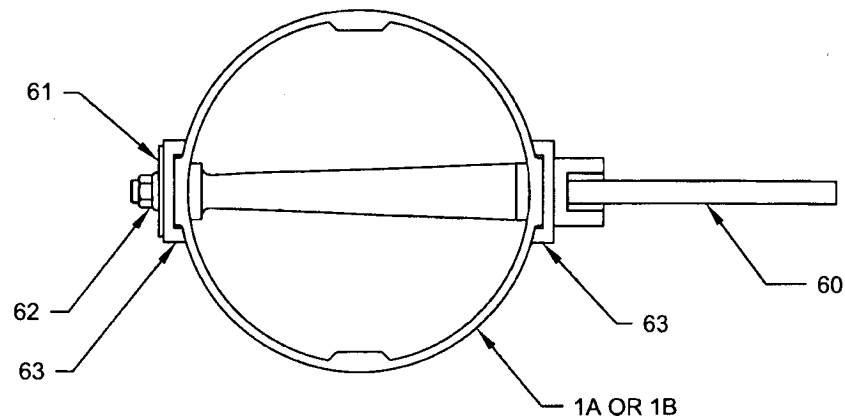
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

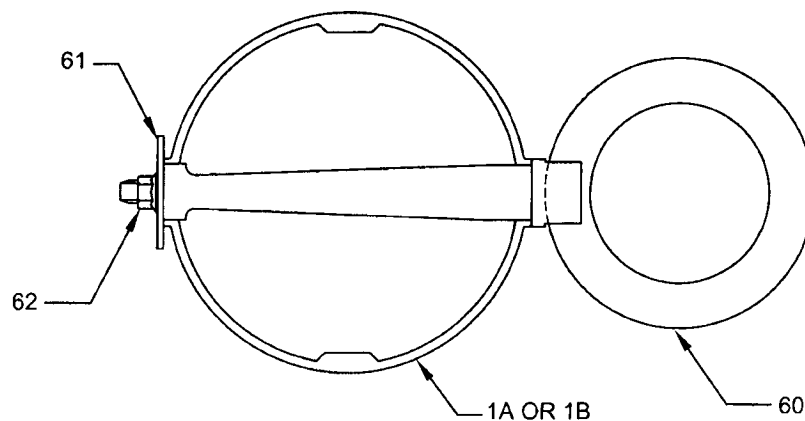
NOTE: Date & initial all entries

INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9450 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SKIDTUBE INSTALLATIONS | NTS |
| DATE | 09.02.24 | COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries